

Date: Monday, 2/5/2007 4:03:11 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WASHER
Job Number : 30662	
Estimate Number : 12298	
P.O. Number : N/A	Part Number : D34931
This Issue : 2/5/2007 S.O. No. : N/A	Drawing Number : D3493 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 2/5/2007 Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 29798	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 2/23/2007 Qty: 30 Um: Each
Checked & Approved By : <u>[Signature]</u> 07.02.06	
Comment : Est Rev: A New Issue 06-02-28 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R1000	Inventory
-----	-----------	-----------



Comment: Qty.: 0.0306 f(s)/Unit Total : 0.9167 f(s)
 1.00" 304 ROUND BAR
 (M304R1.000)
 Batch: M17002

DIP 07/04/14

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL

1-Turn as per Folio FA626 & Dwg D3493

2-Deburr

DIP 07/04/14 / A.F 07/04/17

(41)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

GR 07/04/17

TURN
→
OVER

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

02/04/19 (41)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock


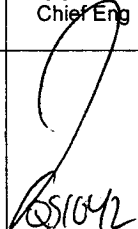

Location: _____

07/04/19 (41)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.04.19	3	INSIDE DIAMETER IS $\phi 0.570$ nominal nominal is $\phi 0.516$	RH PER 07.04.19 QSS OUT	ACCEPTABLE DEVIATION SEE ATTACHED E-MAIL	RH 07.04.19	 07/04/19	 07/04/19	 07/04/19

NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WASHER

Job Number: 30662

Part Number: D34931

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(41)

Comment: FINAL INSPECTION/W/O RELEASE

207104/20

Job Completion



u 8704-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

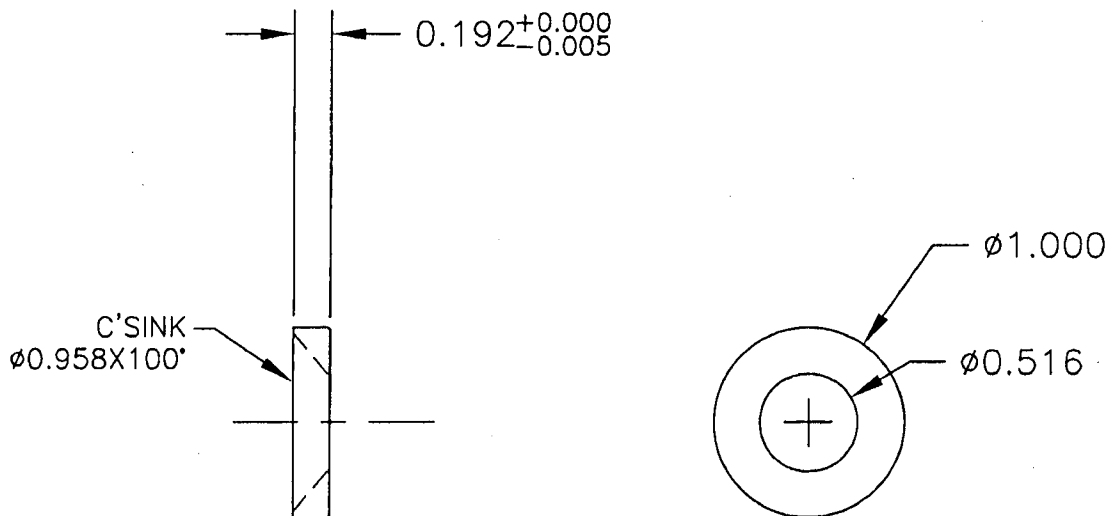
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN PH	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3493	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE WASHER	SCALE 1:1
A	06.01.04	NEW ISSUE	



D3493-1 WASHER

D3493-1 WASHER

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL $\phi 1.000$ ROUND BAR
(REF DART MATERIAL SPEC M304R1.000)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RECEIVED
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30662

RELEASED
06.02.07 [Signature]

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Peter Hum

From: Peter Hum [phum@dartaero.com]
Sent: April 18, 2007 12:00 PM
To: 'David Shepherd'
Cc: 'Jason Murdoch'
Subject: D3493-1 washer
Attachments: 350apicalbolt 001.jpg; D3493-1A-big ID.pdf

David,

Production is making a batch of D3493-1 washers and the inside hole dimension is 0.570 OD (0.516 is the nominal). These washers are used when the customer is installing an Apical float system using the long countersunk bolt provided by Apical. The purpose of this washer is to convert the countersunk head of the Apical bolt to a flat head in order to fit the Dart D2741 blade.

This deviation was caused by over deburring

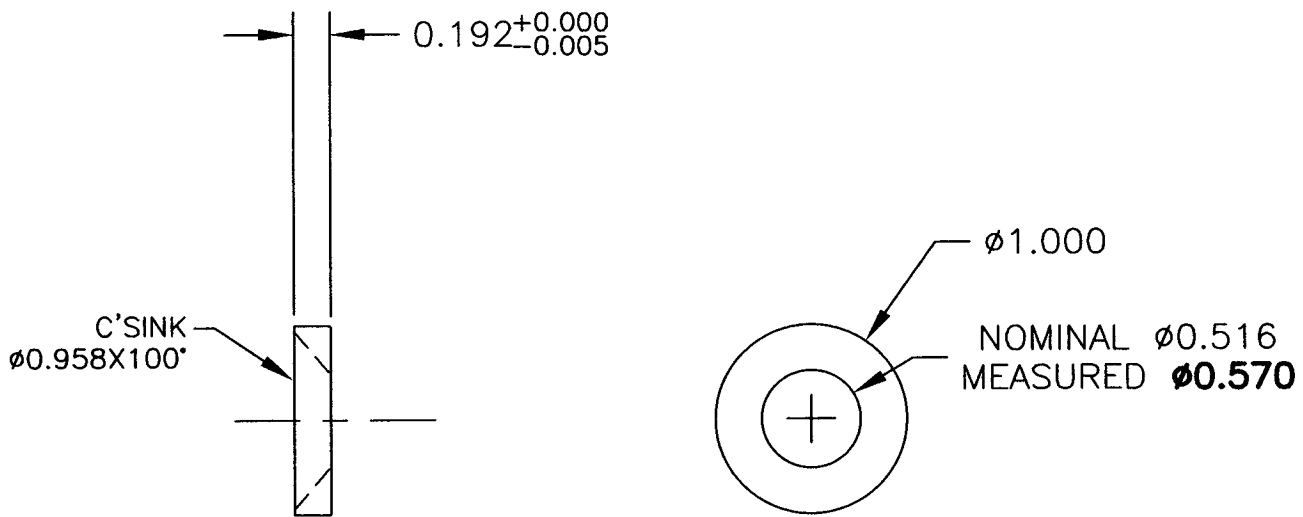
I've attached pictures showing this washer with the Apical bolt. This deviation does not affect the form or intended function of the washer.

Is this deviation acceptable?

Peter

19/04/2007

DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO. D3493	REV. A SHEET 1 OF 1
DATE 06.01.04	TITLE WASHER		SCALE 1:1
A	06.01.04	NEW ISSUE	



D3493-1 WASHER

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